



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2661-2**Job Sheet 187082****Part No:** D2661-2**Job Qty:** 8 pcs**Part Name:** Saddle, RH, Fwd, Aft, Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/27/18**Job Tracking No:****Due Date:** 12/19/18**Created By:** Jesse White**Type:** SOLD**Description:**

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	HAAS 4 Axis	8 pcs	12/19/18		0.00	13.13	HAAS - 1			SBL 18/12/09
							HAAS - 2			
							HAAS - 3			
							HAAS - 4			
110	Conventional Mill - 1 - B4B	8 pcs	12/19/18		0.00	0.51	Conventional Mill - 1 - B4B			SBL 18/12/09
							Conventional Mill - 2 - B4B			
120	QC 2	8 pcs	12/19/18		0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 11			
							QC 2 - 16			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 38			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			

Pl 11/27/18 12:56 PM dart.white.jesse

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																					
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Description Work Order Deviation			Disposition																																																																				
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 892-5200 Email: sales@dartaero.com www.dartaero.com Container No: S135849 Part: D2661-2 Job No: 187082 Serial No/Batch: S135849 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 12/09/18			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																				
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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
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OTHER :					

				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	8 pcs	12/19/18	0.00 0.31	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	8 pcs	12/19/18	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 16
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 26
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 38
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 6
					QC 3 - 68
					QC 3 - 9
170	Packaging 3-1 - Stock - B4B	8 pcs	12/19/18	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
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					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
180	QC 21 - SA	8 pcs	12/19/18	0.00 0.00	QC 21 - SA - 16

Part Op **100** - (HAAS CNC Vertical Machine), Program part number and batch number MACHINE AS PER DWG AND FOLIO
 Descriptions: FB071 FOLIO REV: _____ DWG REV: _____

110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum START TIME: 1:50 OVEN TEMPERATURE: 320°

FINISH TIME: 2:50 11/30/18

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	8 Ea (1 ea)	100-HAAS 4 Axis	+ 6x 5038654 2x 5054514
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	8	39	0
Part Specifications				
Specifications could not be found.				

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

DART AEROSPACE LTD				Work Order: 187 082	
Description: 206 Saddle, Outboard, Right side				Part Number: D2661-2	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.120	.120	.120	.120	.121
H	0.210	0.230		.224	.225	.224	.224	.225
I	0.615	0.685		0.680	0.680	.680	.680	0.680
J	2.470	2.510		2.500	2.500	2.500	2.500	2.500
K	1.313	1.343		1.322	1.322	1.323	1.323	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.136	1.136	1.136	1.136	1.136
O	0.100	0.180		.132	.132	.132	.132	.132
P	0.100	0.140		.135	.135	.135	.135	.135
Q	0.240	0.260		.249	.249	.250	.250	.249
R	0.677	0.697		.688	.689	.688	.688	.687
S	0.100	0.140		.130	.131	.131	.131	.130
T	1.565	1.585		1.576	1.576	1.576	1.576	1.576
U	0.540	0.560		.550	.550	.549	.549	.550
V	0.912	0.932		.919	.919	.919	.919	.920
W	0.787	0.807		.796	.796	.794	.795	.795
X	5.990	6.010		5.998	5.998	5.997	5.998	5.997
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.499	.500	.500	.500
AA	0.312	0.319		.525	.525	.525	.525	.525
AB	0.990	1.010		1.001	1.001	1.000	1.001	1.001
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.501	.501	.501	.502	.502
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.239	.239	.239	.239	.239
AG	0.510	0.515		.510	.510	.510	.510	.510
AH	0.100	0.120		.120	.120	.120	.119	.119

DAS Accept/Reject

Measured by: 57	Date: 18/12/10
Audited by: 9-89 mml	Date: 18/12/11
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD		Work Order: 187 082
Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661	Rev: E	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 1	7 2	8 3	4	5
A	3.611	3.621		3.616	3.616	3.616		
B	0.256	0.263		.257	.257	.257		
C	0.315	0.322		.316	.316	.316		
D	2.495	2.505		2.500	2.500	2.500		
E	1.674	1.684		1.679	1.679	1.679		
F	1.357	1.367		1.362	1.362	1.362		
G	0.100	0.140		.120	.120	.120		
H	0.210	0.230		.225	.225	.225		
I	0.615	0.685		.680	.680	.680		
J	2.470	2.510		2.500	2.500	2.500		
K	1.313	1.343		1.323	1.323	1.323		
L	0.178	0.198		.188	.188	.188		
M	0.470	0.530		.500	.500	.500		
N	1.125	1.145		1.136	1.136	1.136		
O	0.100	0.180		.133	.132	.133		
P	0.100	0.140		.135	.135	.135		
Q	0.240	0.260		.250	.250	.250		
R	0.677	0.697		.687	.687	.687		
S	0.100	0.140		.131	.130	.131		
T	1.565	1.585		1.576	1.576	1.576		
U	0.540	0.560		.549	.550	.550		
V	0.912	0.932		.919	.920	.922		
W	0.787	0.807		.794	.795	.795		
X	5.990	6.010		5.997	5.997	5.997		
Y	4.995	5.005		5.000	5.000	5.000		
Z	0.490	0.510		.499	.500	.500		
AA	0.312	0.319		.313	.313	.313		
AB	0.990	1.010		1.001	1.001	1.001		
AC	1.245	1.255		1.250	1.250	1.250		
AD	0.490	0.510		.502	.502	.501		
AE	3.745	3.755		3.750	3.750	3.750		
AF	0.235	0.240		.239	.239	.239		
AG	0.510	0.515		.510	.510	.510		
AH	0.100	0.120		.119	.119	.119		

DAS Accept/Reject

Measured by: 57	Date: 18/12/10
Audited by: 9-89 <i>mmh</i>	Date: 18/12/11
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
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